



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3110

Job Sheet 171158



Part No: 646.3110

Job Qty: 12 ea

Part Name: Channel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/18

Job Tracking No: see also open job 170452

Due Date: 2/21/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/20/18	2/20/18	0.00	0.00	Start Up Machining-1		Kt 18-04-08
100	Bandsaw	12 pcs	2/20/18	2/20/18	0.00	0.66	Bandsaw1		Kt 18-04-08
110	CNC Vertical Machining	12 pcs	2/21/18	2/21/18	0.43	13.33	HAAS1-1		Kt 18-04-08
120	QC	12 pcs	2/21/18	2/21/18	0.00	0.00	QC2 Machining-1		Kt 18-04-08
130	QC	12 pcs	2/21/18	2/21/18	0.00	0.00	QC8 Machining-1		7/2/18/04/09
140	Outsource	12 pcs	2/21/18	2/21/18			ATG001-VC	10	CT 18-4-9 ATG 18-4-9
150	Packaging	12 pcs	2/21/18	2/21/18	0.00	0.00	Packaging2		ATG 18-4-9
155	QC	12 pcs	2/21/18	2/21/18	0.00	0.00	QC5		7/2/18/04/09
180	Packaging	12 pcs	2/21/18	2/21/18	0.00	0.00	Packaging3-1		9-89 ATG 18-4-9
190	QC21-SA	12 Ea	2/21/18	2/21/18	0.00	0.00	QC21		21 9-89

Part Op 100 - Cut Blank at 15.00"

Descriptions: 110 - 1-Machine per folio FB145

140 - Issue P/O to ATG : 0039539 1- Hard Anodize Black and Prime as per Dwg 646.3100

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

APR 2 2018

Job BOM

m7075 t6 S 1.500x1.500
m137561-146

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	14.600inches ± 0.010	14.610 14.590		
2	Channel	13.130inches ± 0.010	13.140 13.120		
3	Channel	0.090inches ± 0.010	0.100 0.080		
4	Channel	0.470inches ± 0.010	0.480 0.460		
5	Channel	0.750inches ± 0.010	0.760 0.740		
6	Channel	83.000Degrees ± 0.500	83.500 82.500	Angle	



Container No: S059056



Part: 646.3110

Job No: 171158

Serial No/Batch: S059056

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/08/18

7	Channel	0.880inches $\pm$ 0.010	0.890 0.870	
8	Channel	0.645inches $\pm$ 0.005	0.650 0.640	
9	Channel	0.110inches $\pm$ 0.010	0.120 0.100	
10	Channel	0.120inches $\pm$ 0.010	0.130 0.110	
11	Channel	0.209inches $\pm$ 0.005 - 0.001	0.214 0.208	Diameter
12	Channel	0.409inches $\pm$ 0.005	0.414 0.404	
13	Channel	0.420inches $\pm$ 0.002	0.422 0.418	
14	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
15	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
16	Channel	2.188inches $\pm$ 0.002	2.190 2.186	
17	Channel	2.187inches $\pm$ 0.002	2.189 2.185	
18	Channel	0.785inches $\pm$ 0.002	0.787 0.783	
19	Channel	2.395inches $\pm$ 0.002	2.397 2.393	
20	Channel	0.669inches $\pm$ 0.002	0.671 0.667	
21	Channel	0.372inches $\pm$ 0.002	0.374 0.370	
22	Channel	0.334inches $\pm$ 0.002	0.336 0.332	
23	Channel	0.175inches $\pm$ 0.002	0.177 0.173	
24	Channel	0.130inches $\pm$ 0.002	0.132 0.128	

Plex 1/31/18 10:01 AM Dart.Gagnon.Michelle

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

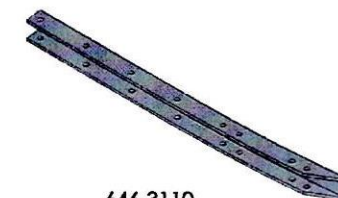
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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NOTES:

1. MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-225/9
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2. COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER; PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

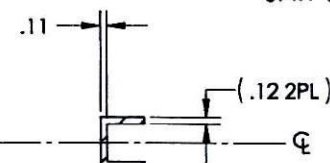
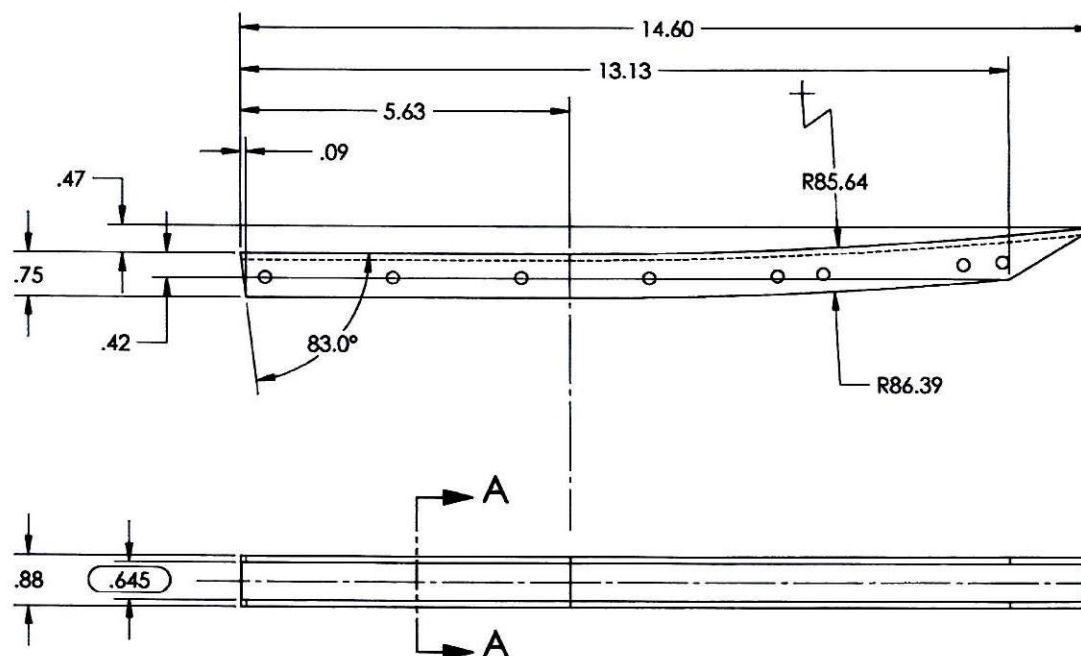
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3110

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171158

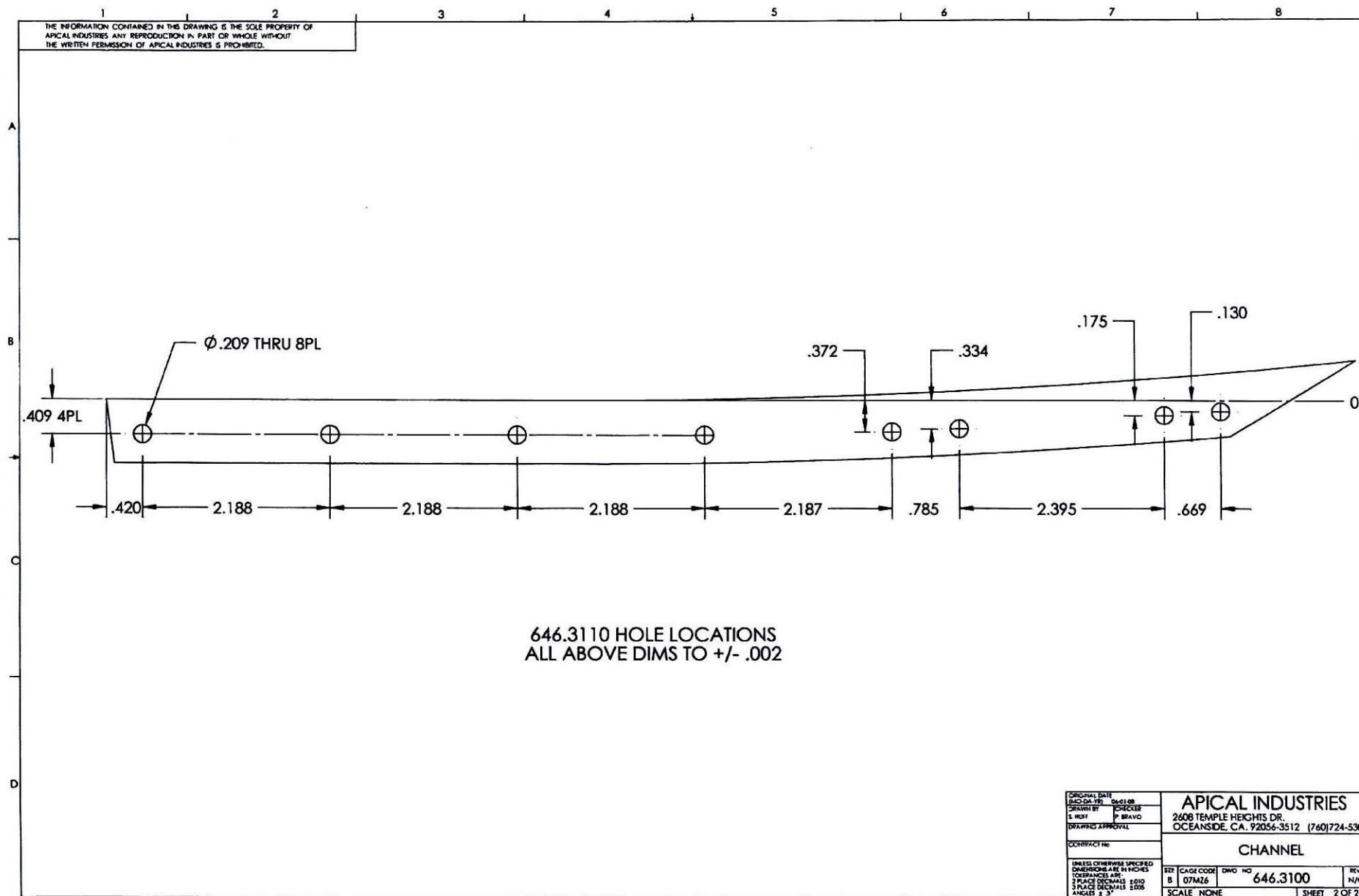
JAN 31 2018



SECTION A-A

QTY	646.3110	CHANNEL	APICAL INDUSTRIES
NEXT ASSY (S)	646.4000	DESCRIPTION	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
ORIGINAL DATE	08-01-08	PART #	646.3100
DRAWN BY	1. HUP	MATL	ALUMINUM 7075-T651 AMS-QQ-A-225/9
CHECKED	1. HUP	SPEC.	CHANNEL
DESIGNED	08-25-08 P. BRAVO	SCALE	NONE
CORRECTED		SHEET	1 OF 2

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039539**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039539

PO Date: 4/9/18

Due Date: 4/27/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171156	646.2910	Deflector Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	4/27/18	8 pcs	0 pcs	8 pcs	\$50.80/pcs	\$406.40
2	171158	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	4/27/18	12 pcs	0 pcs 12x	12 pcs	\$13.45/pcs M18/6/18	\$161.40
3	174111	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	4/27/18	6 pcs ✓	0 pcs 6x	6 pcs	\$13.45/pcs M18/6/18	\$80.70

DAS
11
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914968

Date: 18-Apr-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: 646.2910 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22854		Rev: N/C PO: PO039539 Line: 1
12 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22855		Rev: NC PO: PO039539 Line: 2
6 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22856		Rev: NC PO: PO039539 Line: 3
11 ea	Part: 649.5212 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22857		Rev: C PO: PO039539 Line: 4
11 ea	Part: 649.5214 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22858		Rev: C PO: PO039539 Line: 5
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914968

Date: 18-Apr-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22858	PO: PO039539	Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>18/04/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			